



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C10-12-0
Job Sheet 180037



Part No: C10-12-0

Job Qty: 2 ea

Part Name: Solenoid



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/28/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C10-12 Rev 2 IPP Rev A 18.04.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		6/29/18	0.00	0.00	Start Up Machining-4		
100	Mill Conv	2 pcs		6/29/18	0.50	0.40	Mill Conv 2		
110	QC	2 pcs		6/29/18	0.00	0.00	QC2 Machining-5		
120	QC	2 pcs		6/29/18	0.00	0.00	QC8 Machining-5		
130	Packaging	2 pcs		6/29/18	0.00	0.00	Packaging3-2		
140	QC21-SA	2 Ea		6/29/18	0.00	0.00	QC21		

DAS
39
9-89

Part Op 100 - 1-Drill hole in shaft. Shaft should be retracted when drilled. Studs facing you rotate shaft COUNTER clockwise to the Descriptions: end of stroke, push shaft into solenoid then drill as per DWG sheet 2 2-Engrave S/N and/or P/N number using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
H-2553-020	Solenoid	2 Ea (1 ea)	90-Start up Operation	S083732

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	H-2553-020	2	48	0

Part Specifications

Specifications could not be found.



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Plex 6/28/18 7:12 AM Dart.lajeunesse.marie

Container No: S085167



Part: C10-12-0

Job No: 180037

Serial No/Batch: S085167

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 06/28/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

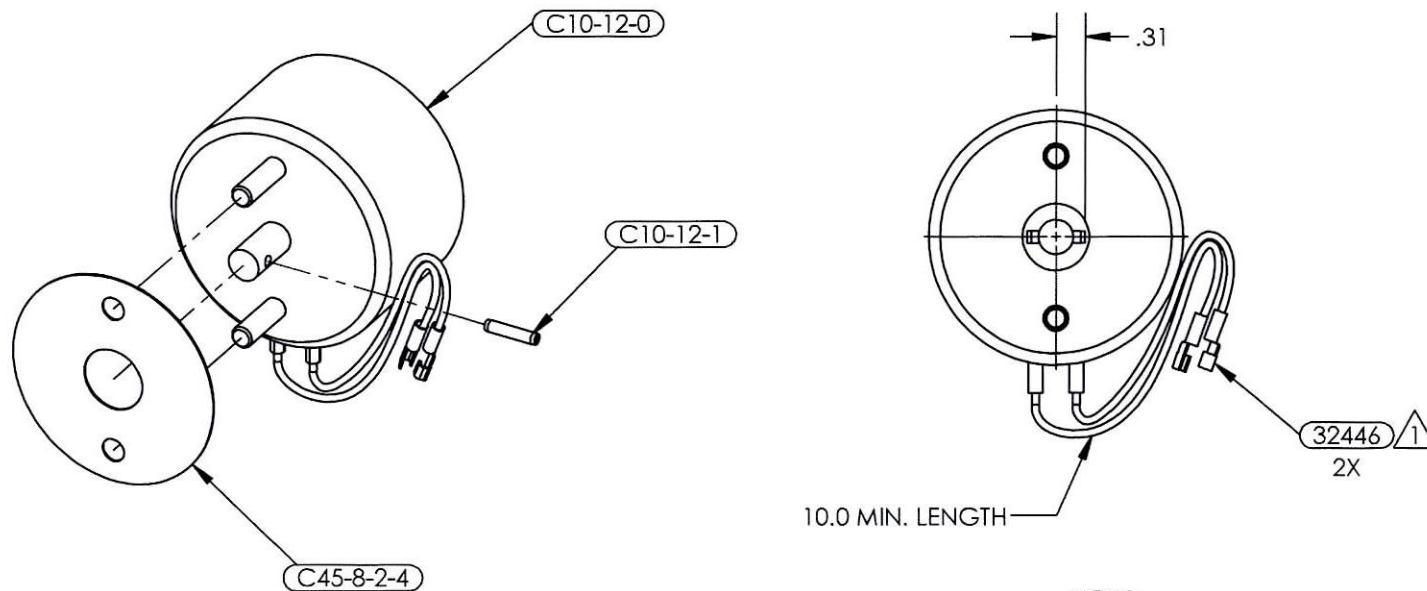
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		AS DRAWN BY CANAM	5/13/2013	CFS	
2	14-0090	CH'D TITLEBLOCK WAS RED BARN IS DART. ADDED 10.0 MIN LENGTH NOTE. ADDED SPACER C45-8-2-4, & CONNECTORS 32446. C10-12-0 ADDED ENGRAVE BATCH NUMBER NOTE. C10-12-1 CH'D MAT'L WAS STEEL IS S.S., ADDED B/O INFO #92383A695.	7/25/2014	JAG	RW



NOTE:

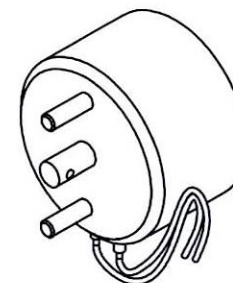
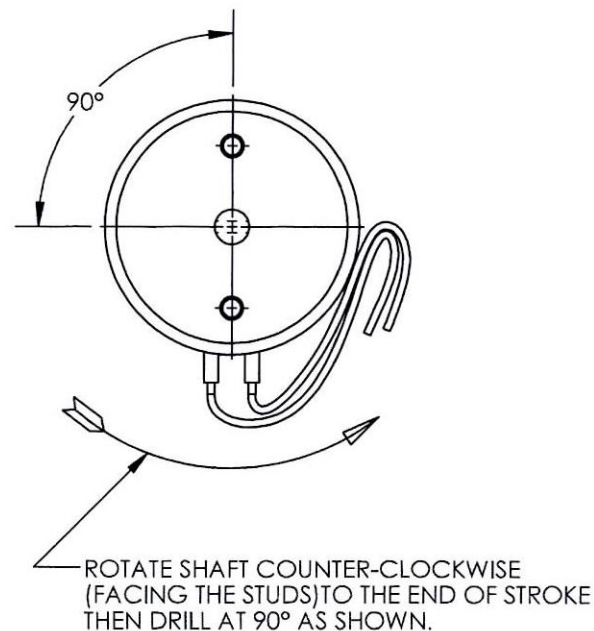
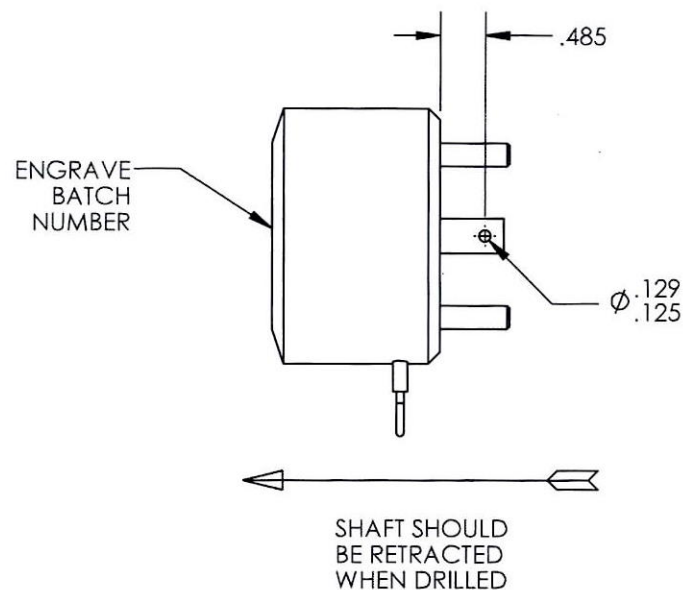
1 CONNECTORS SUPPLIED LOOSE WITH ASSEMBLY.

DART AEROSPACE	
TITLE SOLENOID ASSY	
DWG NO. C10-12	REV 2
MAT'L	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D Weid</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE 1:2	DATE 4/26/2002 SHEET 1 OF 2

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	C10-12-0	1	SOLENOID		H-2553-020 (MODIFIED)	2
		B/O	C10-12-1	1	SPRING PIN	S.S.	Ø1/8 X 5/8 MCMMASTER-CARR #92383A695	1
			C45-8-2-4	1	SPACER		SEE DWG. C45-8-2	1
		B/O	32446	2	22-16 AWG KNIFE CONNECTOR		ALLIED ELECTRONICS 32446	1

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	01-0090	C10-12-0 ADDED ENGRAVE BATCH NUMBER NOTE.	7/25/2014	DPD	JAG



C10-12-0
SOLENOID

DART AEROSPACE	
TITLE SOLENOID ASSY	
DWG NO. C10-12-0	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CANAM APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 12/19/2001 SHEET 2 OF 2